April-22-13 1:02:31 PM

tem ID: Revision ID: Item Name:	D3916-041 Rib Assembly			Accept	*N900	<u> </u>	100)* s	etup Star	I VI	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 6.00 Req'd Qty: 6.00	*6' *6'		Cust Item Customer:						
Approvals:		: MLJ)ate:)ate:		R	tun Star Stop	!//	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr	,		Įį.						,
D3916	A		,								
*100 *100* Large Fab		*** Make I side of tube 3- Trim acc	be with manuel pipe be ine at 9.00" and use jip when bending*** sess tube material to fi	0.00 0.00 ender as per DT9567 Ig for other lines, and ensure sea inish size as per dwg D3916 dwg D3916-1 using DT9605	in place on			®	CC	13-6-	19
*105 *105* QC Quality Control		QC6- Inspect dimension Memo	ns to drawing	0.00				B	13.01	o.19	DAN Og S

												DQA:	Date:	
NCR:	Yes	/ No				WORK ORD	ER NON-C	ONF	ORN	AANCE / UP	DATE			
							10.2.					QA Closed:	Date:	
Work Ord	<u>.</u> .					DISPOS	SITION				AGAINST D	EPARTMENT	/PROCESS	
Work Ord	er					•	Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.						Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•						Use-as-is	-		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Orde	r Update			Large Fab	Composite		Supplier	
			, , , , , , , , , , , , , , , , , , ,		-							T c: 0	·	
Root					ì	ption of work ord	-		tial		tion	Sign &	,, :c:	061
Cause		Date	Step	Qty	(or Non-conforma	nce	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш													
Equip/Tooling								1			Y	1		
Operator	Ш		!											
Material						<i>P</i> ,						İ		
Setup							*,						1 .	·
Other	П		1											
Process														• 5
Supplier				1										
Training				· ·										
Unapproved													<u> </u>	<u> </u>
							F/	AULT	CATE	GORY				
Land	ing (Gear				Genera	l					_		1
		Bending				Bend		G	irain			Ovalized		Pressure/Forced
	Γ	Centre No	ot Conce	ntric to	o/s Γ	BOM/Route		Шн	lardwa	re	L	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damage	ed	[]ir	nspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		∏lr	nstruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
e	_	Cuffs	-			Contamination		\square	/lainte	nance		Part Moved		·

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H. FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

April-22-13 1:02:31 PM

Item ID: Revision ID:	D3916-041			Accept	*N900	040	100)* ፡	Setup Star	1.71	S1*
Item Name:	Rib Assembly	<i>'</i>							Stop	° *N	S2*
Start Date: Required Date	4/22/13 : 4/22/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:	:				
Reference:	•	•									
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		. I	Run Star	!/	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:			Stoj	*N	R2*
Sequence ID/ Work Center I	D	Operation Description Weld per dwg A/R S.S	rod Batch: R17	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*107 Large Fab		Мето	shing as per dwg D391	0.00				<u>CC</u>	13-6-	- 19	· · · · · · · · · · · · · · · · · · ·
		2- grind we									
110		QC5- Inspect part comp	oleteness to step on W/G	O.00 .				•	_		DAPI
110 QC Quality Control		Memo		0.00				<u> </u>	13.06	·\ <u>\$</u>	09
120		QC10- Inspect visual pe	er OSI004- ground wel	ds 0.00							
120 QC Quality Control		Memo		0.00				B	13-06	·15	DAG 09 289

NCR:	Yes	/	No

DQA:___

_Date: ___

NCR: Ye	s / No				WORK ORDER NON-O	CONFOR	MANCE / UP	PDATE	QA Closed:	Date	:
Work Order					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No)				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	→	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	<u> </u>	<u> </u>		Descri	ption of work order update	Initial	Ac	ction	Sign &	<u> </u>	
Cause	Date	Step	Qty	. (or Non-conformance	Chief Eng	g Desc	cription	Date	Verification	QC Inspector
Ooc/Data quip/Tooling									:		
Operator Material										· .	
etup Other		,							-		
Process Supplier					•						
raining Jnapproved				•							
		-			F	AULT CAT	EGORY	·			
Landing	g Gear			-	General				_	_	·
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	_BOM/Route	Hardw	are are		Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	⊢ ⊣ '	tion Incomplete	·	Part Incorre	⊢	Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete	/Unclear	Part Lost/M	_	Wrong Stock Pulled
	Cuffs			L	Contamination	Maint	tenance		Part Moved		
. [Heat Trea	at		. L	Countersink	Mislat	peled		Positioned V		_
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	'Surge	Other
'[Ripples in	n Bend	i		Drill Holes	Offset					
•	Torque W	Vaves in 1	Extrusio	n 🗌	Drawing	Out of	f Calibration				
. [Turning S	equence	!		Finish	Out of	f Sequence				
		ist in Tul	he		Folio	Outsic	de Dimensions				

100357

Page 3

Quality Control

April-22-13 1:0	02:31 PM								
Item ID: Revision ID:	D3916-041			Accept	*N900	0401	NN*	Setup Sta	10'21
Item Name:	Rib Assembly							Sto	*NS2*
Start Date:	4/22/13	Start Qty: 6.00	*6*		Cust Item I	D:			
Required Date	: 4/22/13	Req'd Qty: 6.00	*6*		Customer:				
Reference:								- 0.	
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:		Run Sta	"NR1"
	QC:		Date:	SPC (Y/N):	D:	ate:	 .	Sto	*NR2*
Sequence ID/ Work Center I	ID	Operation Description Identify as per dwg & Stock	k Location: W/M	Set Up/ Run Hours	Tool ID	Tool# Pl	ode Qty	Qty	Reject Insp. Number Stamp
130 Packaging		Мето	004	0.00			CC	13-6	6-19
Packaging									
140		QC21- Final Inspection - V	Vork Order Release	0.00	, 	,			
1 4 0		QC21- I mai inspection - v	TOIR OTHER RESEASE	0.00	!				13-06-20
OC		Memo		0.00				MCS	15-06 CD

R113-06-30

			DQA:	Date:		_
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			,	

						=	<u> </u>	QA Closed:	Date:	
Work Orde	er:	•			DISPOSITION		AGAINST (DEPARTMENT	/PROCESS	
Part N	lo.				Rework Scrap Use-as-is Work Order Update	-} I	Skid-tube Crosstube Machining Small Fab moforming Finishing Large Fab Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	iption of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator										
Material		-			•			İ		
Setup	- 					1				
Other	-									
Process		ļ	•							
Supplier										
Training		1		<u>.</u>						
Unapproved										
					F	AULT CATE	EGORY			
Landi	ng Gear	•			General		_		. · · · · · · · ·	-1
•	Bending		•		Bend	Grain	<u>L</u>	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw	are	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	Inspect	tion Incomplete	Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instruc	tions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	—	enance	Part Moved		
	Heat Trea	at			Countersink	Mislab	· •	Positioned \	_	7
	Inspectio		Tube		Cut Too Short	Misrea		Power Loss/	Surge	Other
	Ripples ir		4,		Drill Holes	Offset			· · · · · · · · · · · · · · · · · · ·	
	Torque Waves in Extrusion Drawing						Calibration			
	Turning S	Sequence	<u> </u>		Finish	${f oxed{H}}$	Sequence		· · · · · · · · · · · · · · · · · · ·	
	Wave/Twist in Tube				Folio	Outsid	e Dimensions			

Work Order ID:

100357

Parent Item:

D3916-041

Parent Item Name:

Rib Assembly

Start Date: 4/22/13

Required Date: 4/22/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	316.0000	7	42	PC	13-6	10
Bushing					,				026	, .y. - -,-		15-6	-/7
				Location		Loc Oty	Lo	oc Code					
				WA004		316			<u> </u>				
				6648		1							
				7921		" 1 } -							
				8346 8655		20			-				
				8823		1 3							
				8978	0	3							
				9078		11							
				9808 9875	_	30 240			(3	(6x)			
M304TS0.750W.049	•	Purchased	No			100	f	970.7307	4.166	26.3115	579 CC	/>/	19
304 SQ Tube .75x.75x.049	₽W						1					_/_S= (<u> </u>
				Location		Loc Qty	<u>L</u>	oc Code				τ	•
				MAT017		241.6869			<u>*</u>				
				1244	92	241.6869							
				WA006		729.0438355							
				1232		16.0438355							
				12 <u>34</u> 1251	- 1	113 600			(रद	.0821			•
				1231		000			1	<u> </u>			

											DQA:	Date	:
NCR:	Yes /	No				WORK ORDER NON-	01	NFORM	MANCE / UPDATE	E			
		· · ·									QA Closed:	Date	:
Work Orde	oŕ.					DISPOSITION			AC	GAINST DE	PARTMENT	/PROCESS	·
Work Ordi						Rework	1		Skid-tube Cro	sstube	1	Water Jet	Engineering
Part I	No.					Scrap		6		nall Fab	Pro	d. Eng. Coor.	Quality
:						Use-as-is	1	1	~ <u>—</u>	nishing	-	re/Packaging	Other
NCR I	No					Work Order Update]		Large Fab Com	nposite]	Supplier	
	<u> </u>	,											_
Root					l .	ption of work order update	1	Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description	<u> </u>	Date	Verification	QC Inspector
Doc/Data	Ш				ļ								
Equip/Tooling	Ш												
Operator	Ш												
Material	Ш												
Setup	Ш	1					l						
Other	Ш												
Process	Ш						1						
Supplier	Ш		,										
Training	Ц												
Unapproved													
						F	AUL	LT CATE	GORY				
Landi	ng Gea	ır			_	General		-		_	-	_	_
	Ве	nding				Bend		Grain			Ovalized	_	Pressure/Forced
	Ce	ntre No	t Concer	ntric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	L Cr	acks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	-	Weld
	Cr	ushed/0	Crimped			Burrs		Instruct	ions Incomplete/Unclear	r L	Part Lost/Mi	ssing	Wrong Stock Pulled
l	Cu	ıffs				Contamination	1	Mainte	enance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

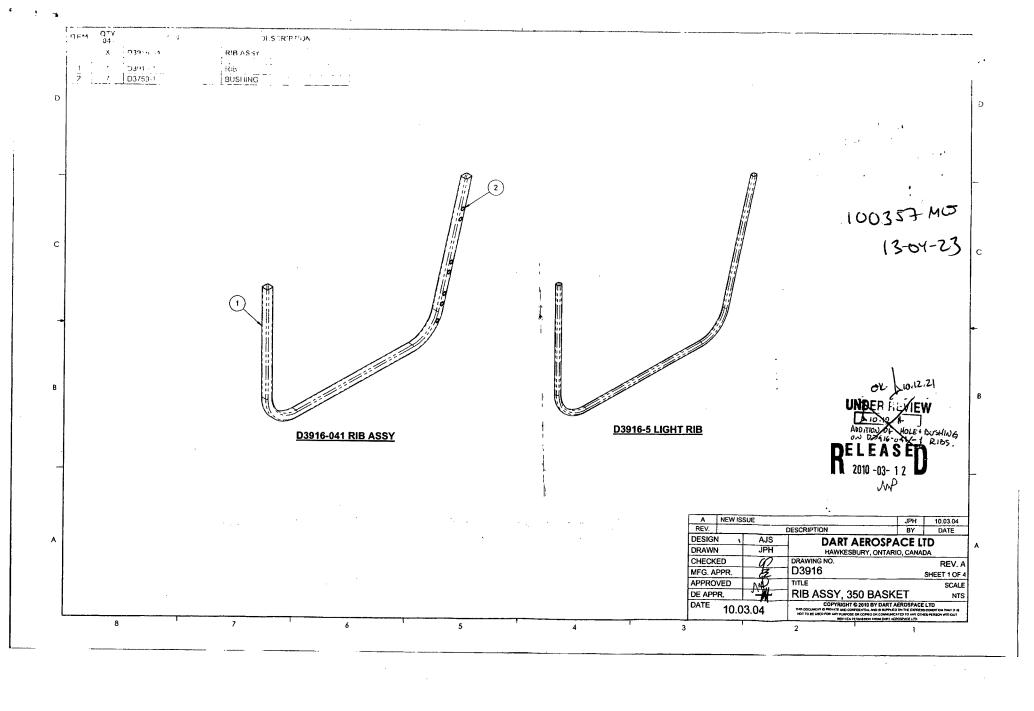
Turning Sequence

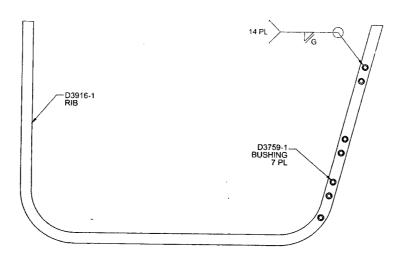
Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion





D3916-041 RIB ASSY

8

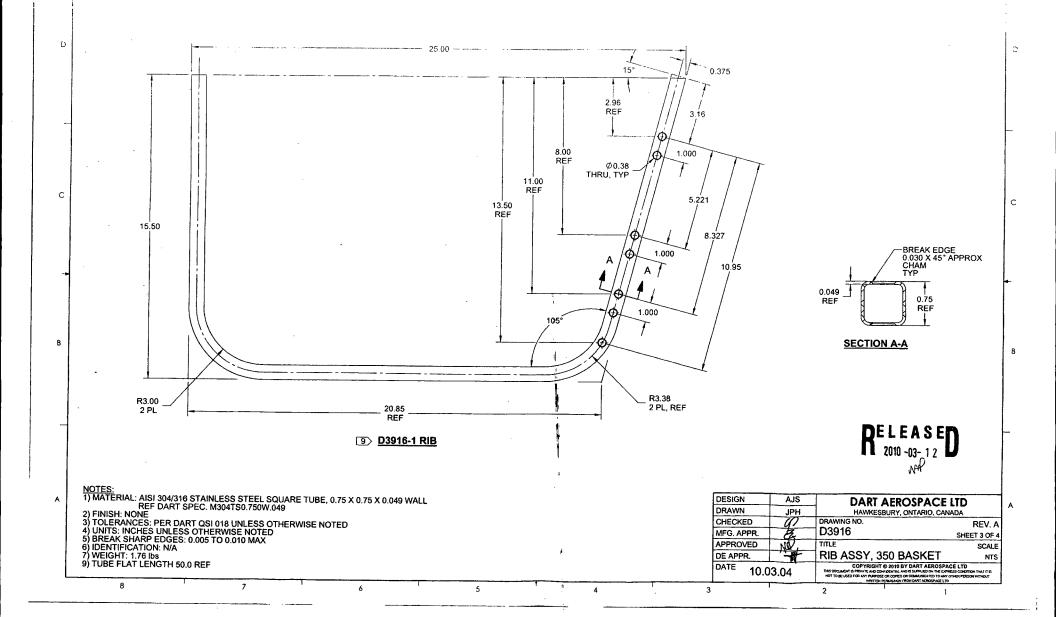
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT -041: 1.84 lbs
8) WELD PER DART QSI 004

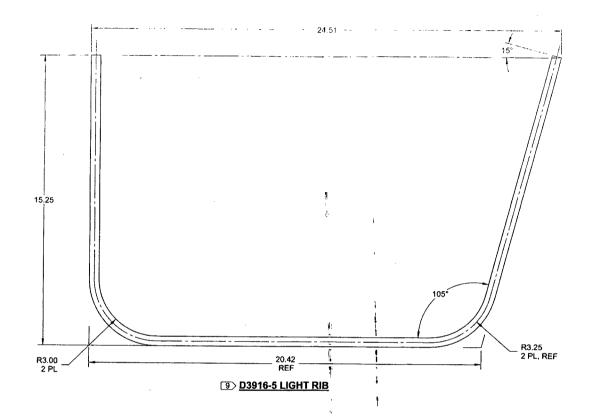
DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN JPH CHECKED DRAWING NO. REV. A D3916 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE SCALE RIB ASSY, 350 BASKET

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PRODUCED IN RECORD OF THE COPYRIGHT IN HIS IT IS

PROTOCULARLY IN RECORD OF THE ART TO NOT THE COPYRIGHT WHITE IN THE INTERPORT OF THE PROPERTY DE APPR. DATE 10.03.04





RELEASED

NOTES;
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.07 lbs
9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE	ITD				
DRAWN	JPH	HAWKESBURY, ONTARIO, CAN					
CHECKED	9	DRAWING NO.	REV. A				
MFG. APPR.	Z	D3916	SHEET 4 OF 4				
APPROVED	M	TITLE	SCALE				
DE APPR.	-4	RIB ASSY, 350 BASKET	NTS				
DATE 10.0	3.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOQUEST IS PRIVATE AND OSHODOTHOL AND IS AUPRUSO ON THE EXPRESS CONDITION THAT IT IN NOT TO BE USED FOR ANY PURPOSE OR CORPET ON BY COMMENCIATION DAY OF THE PER STORM WITHOUT					